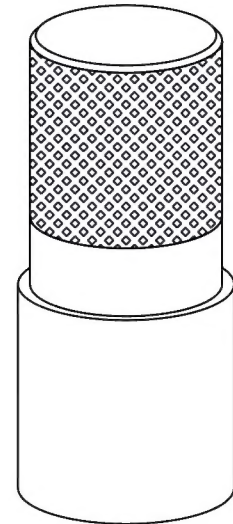
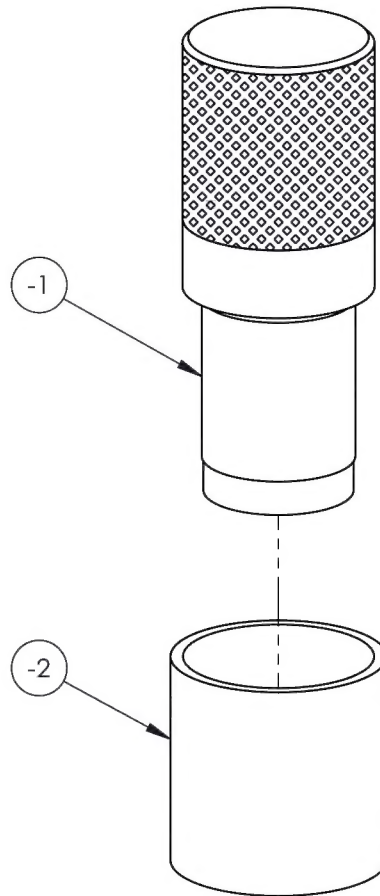


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0096	UPDATED TO NEW STANDARD. -1 CH'D MAT'L WAS 4340 IS 4140/4142. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CORRECTED GD&T. -2 CH'D MAT'L WAS 4340 IS 4140/4142. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	4/21/2017	DPD	JAG



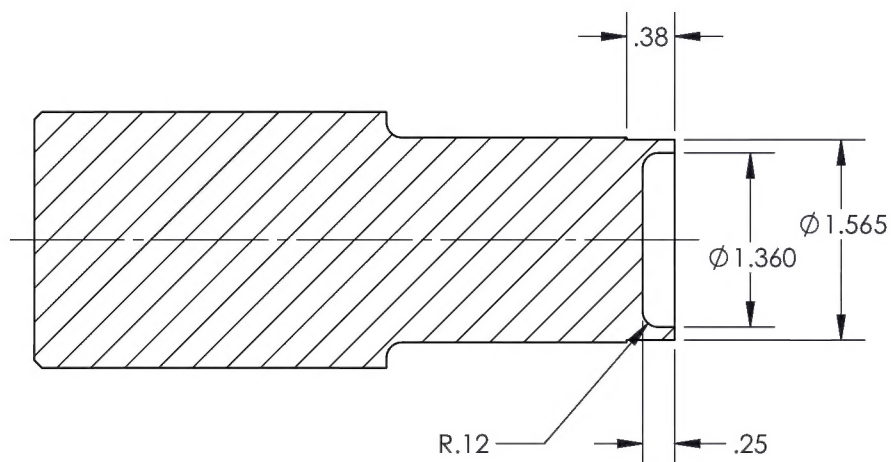
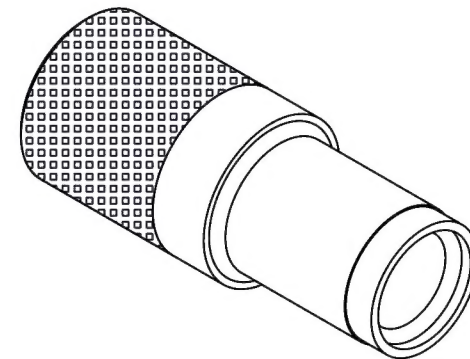
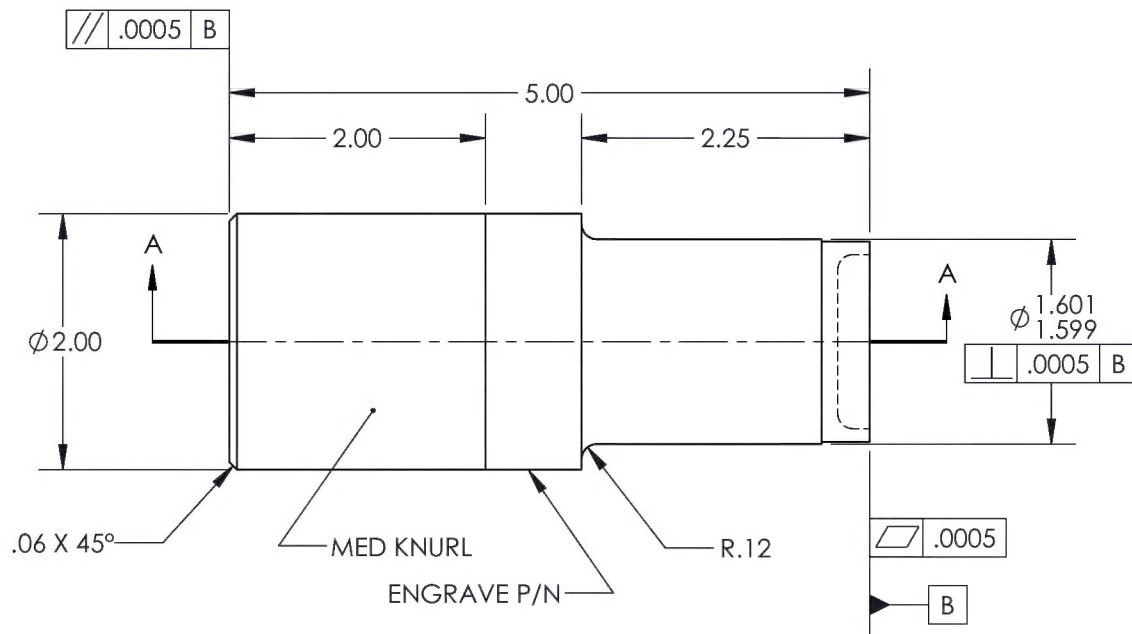
- NOTES:
 1. REF. ROLLS ROYCE T/N: 23033031.
 2. USED WITH RB23033031.

DART AEROSPACE	
TITLE DRIFT, GUIDED-COMP FRONT BEARING RING SEAL	
DWG NO. RB23033033	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .02 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: DD 04/21/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: SM 04/24/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/18/2017	ROLLS ROYCE 250-220R/R1
SCALE 1:2	DATE 4/21/2017
SHEET 1 OF 3	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	DRIFT	4140/4142		2
			-2	1	GUIDE	4140/4142		3

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0096	-1 CH'D MAT'L WAS 4340 IS 4140/4142. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CORRECTED GD&T.	4/21/2017	DPD	JAG



SECTION A-A

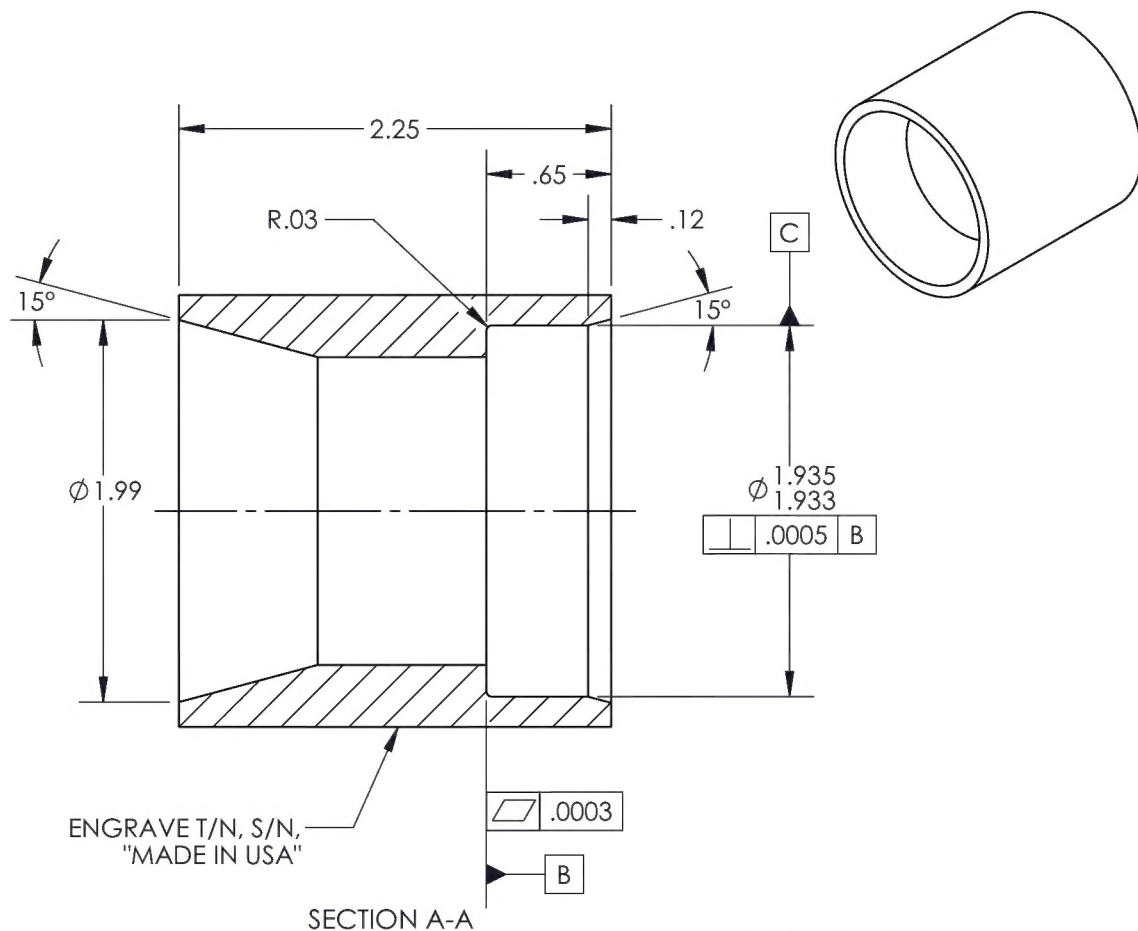
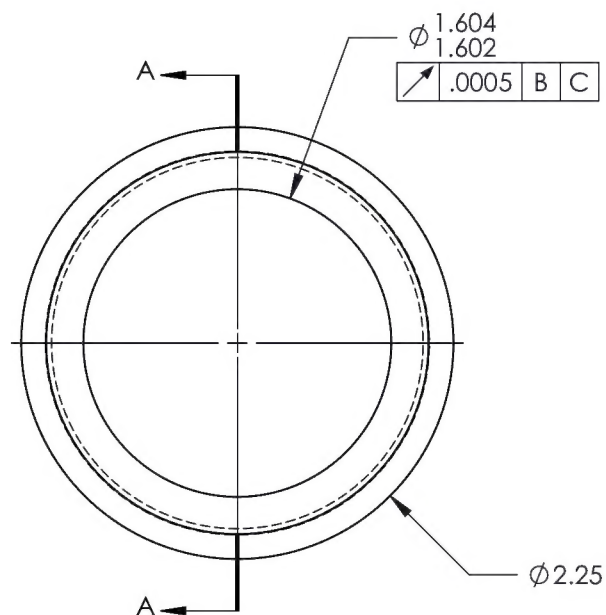
(-1)

DRIFT

DART AEROSPACE	
TITLE DRIFT, GUIDED-COMP FRONT BEARING RING SEAL	
DWG NO. RB23033033-1	REV 2
MAT'L 4140/4142 HEAT RC 46-50 TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .02 ANGLES ± .5° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 04/21/2017	USED ON MODEL
CHECKED: SM 04/24/2017	ROLLS ROYCE 250-220R/R1
OPPS APPR: AA 05/10/2017	
QA APPR: JL 05/10/2017	
APPROVED: JAG 05/18/2017	
SCALE 2:3	DATE 4/21/2017
SHEET 2 OF 3	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0096	-2 CH'D MAT'L WAS 4340 IS 4140/4142. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	4/21/2017	DPD	JAG



(-2)
GUIDE

DART AEROSPACE	
TITLE DRIFT, GUIDED-COMP FRONT BEARING RING SEAL	
DWG NO. RB23033033-2	REV 2
MAT'L 4140/4142 HEAT RC 46-50 TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .02 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 04/21/2017	USED ON MODEL
CHECKED: SM 04/24/2017	ROLLS ROYCE 250-220R/R1
OPPS APPR: AA 05/10/2017	
QA APPR: JL 05/10/2017	
APPROVED: JAG 05/18/2017	
SCALE 1:1	DATE 4/21/2017
SHEET 3 OF 3	